

Work Order ID 71983

Friday, July 15, 2011 7:58:57 AM



Page 1

Item ID: D2873-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 7/15/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 11-07-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 2.700" long

SL 11-07-20



110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-5
Dwg Rev A F1819Folio Rev AA

SL 11-07-25



120

0.00



QC2-Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11-07-25

20



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2873-045

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Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 7/15/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		4.A 11/07/25		20	0		
140 Small Fab Small Fab Small Fab	Small Fab Memo 1-Deburr □2- C'sink as per Dwg D2873	0.00 0.00		2b 11/07/27		20			
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				21	11	07 28	20

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71983

Friday, July 15, 2011 7:58:58 AM



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Item ID:	D2873-045	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Nut Plate Assembly					
Start Date:	7/15/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	7/29/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QS1005 4.1	0.00							
	HandFinish	0.00				20	0		11/10/11
Hand Finishing	Memo								
170	QC3- Inspect Part Finish	0.00							
	QC	0.00				20	0		BK 11-9-11
Quality Control	Memo								
180		0.00							
	Small Fab	0.00							
Small Fab	Memo								
Small Fab	1-Assemble as per Dwg D2873 <input type="checkbox"/> 2-Identify as D2873-045								

SA 11/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71983

Friday, July 15, 2011 7:58:58 AM

Page 4

Item ID: D2873-045

Revision ID:

Item Name: Nut Plate Assembly

Start Date: 7/15/2011 Start Qty: 20.00

Required Date: 7/29/2011 Req'd Qty: 20.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

w/ 11 07 28 20

200

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

RT 11-07-28 20

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/7/29 20

11/07/28 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 15, 2011 7:59:09 AM

Page 1

Work Order ID: 71983

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly




Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5  Nut Plate		Purchased	No			100	Each	126.0000	2	40		8/3 11/07/28 20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST302		125							
				118267		125			40				
				ST303		1							
				116914		1							
M6061T6B0.375X01.00 0  6061T6 BAR .375 x 1.00		Purchased	No			180	f	16.1766	0.225	4.736842		22 11-07-28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT002		16.1766							
				116963		7.4166			4.74				
				117653		8.76							
MS20426AD4-6  Rivet		Purchased	No			180	Each	1,155.000	4	80		8/3 11/07/28 20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST317		1155							
				110139		555			80				
				117505		600							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

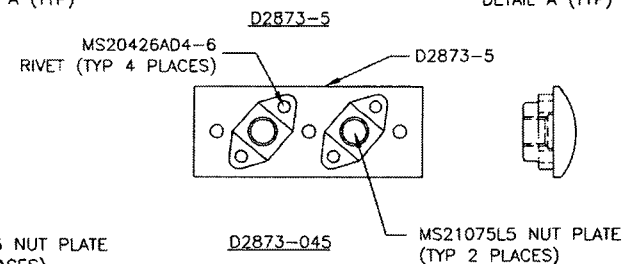
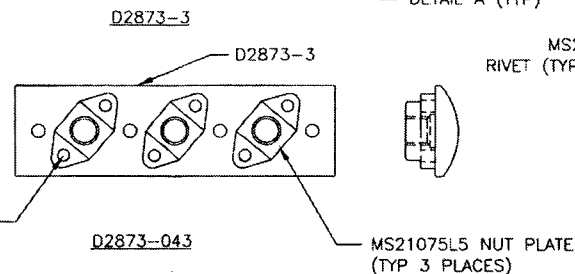
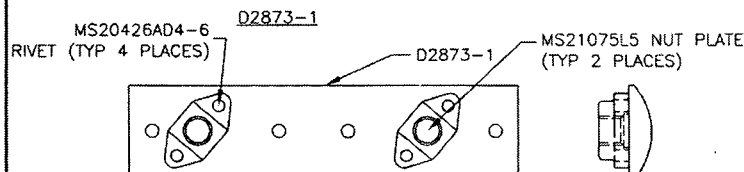
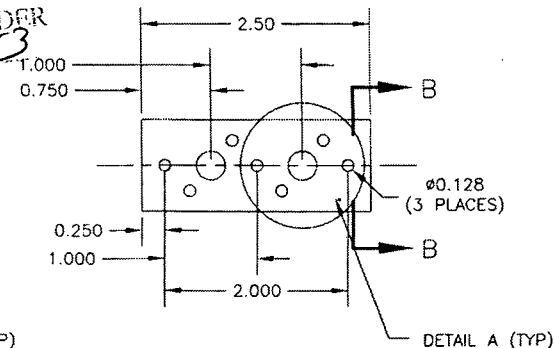
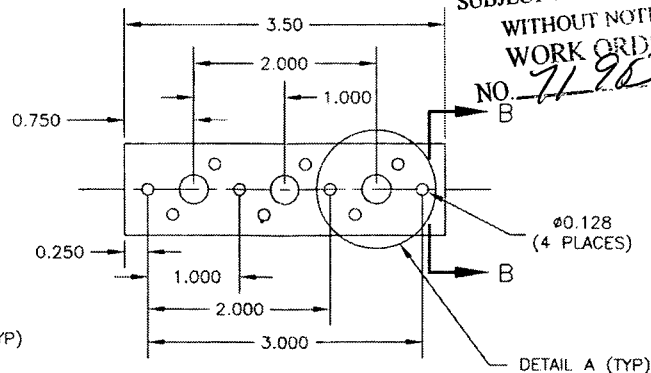
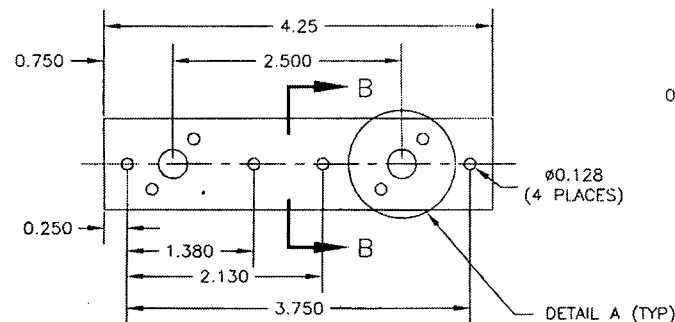
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71983

REV 07-14



D2873-041

MS20426AD4-6
RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE
(TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE
(TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

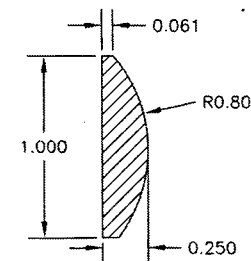
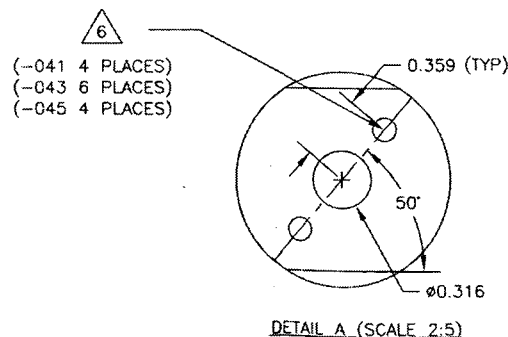
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\phi 0.128$ PILOT + C'BORE CURVED SIDE $\phi 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100'$

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



SECTION B-B (SCALE 2.5)

RELEASED
105-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD WARRICKSURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873 REV. A SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71983
Description: Radius Block		Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	✓		Vernier - 3	
1.000	+/-0.010	1.000	✓			
0.750	+/-0.010	.749	✓			
0.250	+/-0.010	.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
Ø0.128	+0.005/-0.001	.129	✓			
0.359	+/-0.010	.359	✓			
Ø0.316	+0.006/-0.001	.316	✓			
1.000	+/-0.010	1.005	✓			
0.250	+/-0.010	.240	✓			
0.061	+/-0.010	.051	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230 x .125	✓			

Measured by:	JL	Audited by:	B.A.	Prototype Approval:	N/A
Date:	11-07-21	Date:	11/07/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	<i>[Signature]</i>